

Date: Wednesday, 11/21/2007 1:16:24 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ROUND BILLET, ALUMINUM
Job Number : 35953	
Estimate Number : 12286	
P.O. Number : <i>N/A</i>	Part Number : D6103003
This Issue : 11/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D6103 REV B
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 33275	Material : <i>N/A</i>
Written By : _____	Due Date : 12/5/2007 Qty: <i>44</i> Um: Each
Checked & Approved By : <i>11/21/07</i>	
Comment : Est Rev:A New Issue 06-02-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *511*

a) Description: Alluminum round billet

b) Ø3.500" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T7351 (QQ-A-225/9)

Material certification required

*C 107111122**(40)*

2.0	D6103003P	round alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 alum billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

7/12/05 SD (44)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

6 12/2/06 (44)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *CNK**7/12/02.12.31 (44)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 1:16:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND BILLET, ALUMINUM

Job Number: 35953

Part Number: D6103003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(44)

Comment: FINAL INSPECTION/W/O RELEASE

A 08/01/03

Job Completion



min 2008.1.12 CL

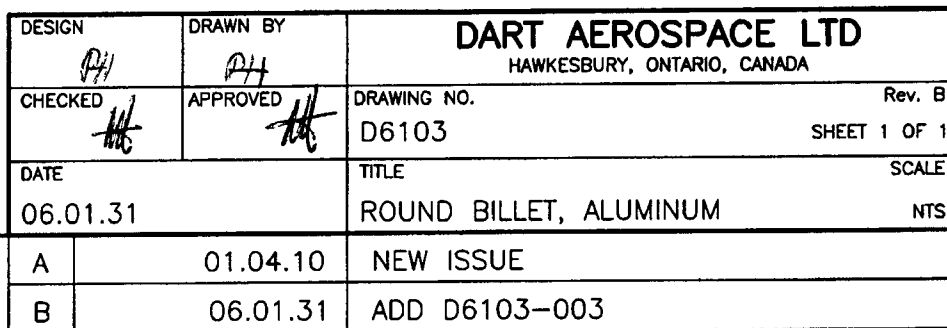
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

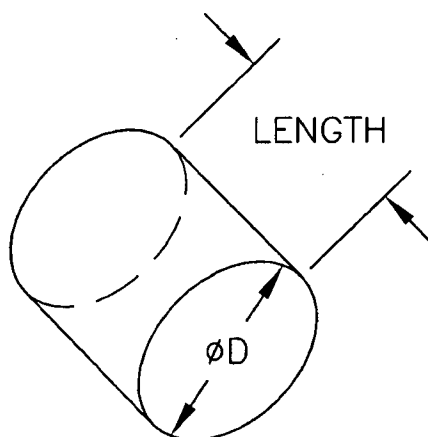
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
06.02.07




ALL DIMENSIONS ARE IN INCHES.

[illegible]

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 Métaux Castle®		CERTIFICATION A.M. CASTLE & Co. (Canada) Inc.		DATE CHARGED-LOADED EXPÉDIÉ 04 DEC 2002		NO. COM-ORD. NO. PCBS		12-101 DLY. WT.	
NO. REQUISITION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO. 5111		COM-TE-ACCT. VEND. SLS TERR. EXPÉDIÉ PAR SHIP VIA 91037 000 400		TRANSNIPMENT *****			

ACHETEUR-PURCHASING AGENT LINDA LACELLE		TELEPHONE 618 682-3336		HC TAXE NO. COM-ORD 4 0 1		REGION LIVRAISON-DEL ZONE C/C		F.A.B.-F.O.B. PREPAID		BILL NO. FEVILLE/EMBALLAGE-B/L NUMBER	
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VIVRE A-SHIP TO: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7		INFORMATION CREDIT-CREDIT INFORMATION REC SEE FRANCE STATUS		ROUTE 01-NL-11/27 31-NL-12/04	
INSTRUCTIONS/LIVRAISON-DELIVERY ***** TRANSNIPMENT ***** PRIOR DIST/ORD: 01 460840		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.) IND-K64035		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)	

DESCRIPTION - ITEM 1 3.5000 RD 7075-T7351 ALUM BAR CF 12.50" BLACK		QTE/UNITE COM-ORDERED 44 PCS PCS		POIDS COM.-WT. ORDERED 534	
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CERTIFICATE OF CONFORMANCE A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc.		INSTRUCTIONS CHICAGO: SHIP 4 FULL BARS CUT IN MONTREAL TOL + 1/16" -0" PRIOR DIST/ORD: 01 460840		COULÉE INFO-HEAT INFO QTE-QTY 00095772 ✓	
WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.		INSTRUCTIONS (CONT'D.) 44x12.5		FORME-SHAPE I.A.C. 8808	

DESCRIPTION - ITEM 2 TERMS AND CONDITIONS OF SALE SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE		INSTRUCTIONS 1 Box		COULÉE INFO-HEAT INFO QTE-QTY	
		INSTRUCTIONS (CONT'D.)		FORME-SHAPE I.A.C. ENT-WHSE	

DESCRIPTION - ITEM 3 ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY	
NOM (LETTRE MOUTEE)-NAME (PRINT ONLY) REC'D PAR-RECEIVED BY DATE RECU-DATE RECEIVED		INSTRUCTIONS (CONT'D.)		FORME-SHAPE I.A.C. ENT-WHSE	

FEVILLE D'EMBALLAGE END PACKING SLIP

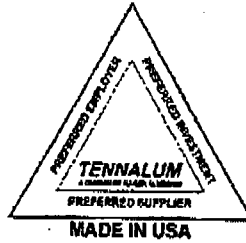
12-5-07: 2:16PM: 4120 Belgreen, Ottawa

16137373870

3/4

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 689
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT

<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER: 01-38073		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 834318	LINE ITEM: 1	SHIP DATE: 11/12/2007	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 987 lbs.	QUANTITY: 7 pcs.	B/L NUMBER: 27031	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20095772	69.7	58.1	14.0	38.7

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.13	0.32	1.5	0.07	2.7	0.20	6.0	0.02			20095772
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

CASTLE METALS CORP.
DATE RCVD 11/13/07
IAC 8808
APPROVED BY

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 97381

Kaiser Order Number: 634318

Line Item: 1

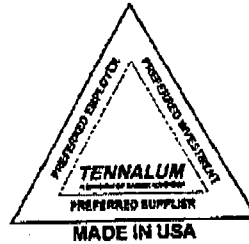
11-13-'07 12:00 FROM-

T-301 P015/050 F-152

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. AS9100B:2004 This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES.

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 97381

Kaiser Order Number: 634318

Page 2 of 2

Line Item: 1